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D3490-5**Job Sheet 185926****Part No:** D3490-5**Job Qty:** 60 ea**Part Name:** Cross Bolt Spacer**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/6/18**Job Tracking No:****Due Date:** 11/30/18**Created By:** Jesse White**Type:** Stock**Description:****Note:** DWG REV A IPP Rev:A New Issue 06-03-03 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		11/30/18	0.00	0.00	Start Up Machining-2		JSD 11-11-28
100	Hardinge	60 pcs		11/30/18	0.00	2.41	Hardinge		11 11
120	QC	60 pcs		11/30/18	0.00	0.00	QC8		KE 2018-11-28
125	Skidtubes	60 pcs		11/30/18	0.00	0.78	Skidtubes-4		BE
130	Packaging	60 pcs		11/30/18	0.00	0.00	Packaging3-1		BE
140	QC21-SA	60 Ea		11/30/18	0.00	0.00	QC21		DAS 21 9-89

Part Op 100 - 1-TURN AS PER FOLIO FA630 & DWG D3490

Descriptions: 125 - Clean spacers with Ultra Aluminum Cleaner Batch: _____

130 - ***STOCK IN SKIDTUBE CELL***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.3125W.058	Aluminum Tube .3125 X .058W	15.9600 ft (.266 ea)	90-Start up Operation	5092702

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.3125W.058	16	51	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	3.085inches	+ 0.030 - 0.000	3.115 3.085	
2	Crossbolt Spacer	0.050inches	± 0.010	0.060 0.040	
3	Crossbolt Spacer	45.0Degrees	± 0.0	0.0 0.0	
4	Crossbolt Spacer	0.313inches	+ 0.006 - 0.001	0.319 0.312	
5	Crossbolt Spacer	0.058inches	± 0.010	0.068 0.048	

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Container No: S132494



Part: D3490-5

Job No: 185926

Serial No/Batch: S132494

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/28/18